

Work Order ID 74877

74877

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October 13, 2011 10:41:27 AM

Item ID: D3490-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cross Bolt Spacer
 Start Date: 10/13/11 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 10/27/11 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/10/11 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3490	Rev A								

100 Hardinge CNC LATHE SMALL 0.00
100 40 0 SL 11/10/23
 Hardinge Memo 0.00
 Hardinge CNC Lathe Small 1-TURN AS PER FOLIO FA629 & DWG D3490
 FOLIO REV: 1
 DWG REV: 1
 2-DEBURR AS REQUIRED SL 11/10/21

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110 40 0 SL 11/10/23
 QC Memo 0.00
 Quality Control SL 11/10/21

120 QC8- Inspect parts - second check 0.00
120 40 0 SL 11-10-23
 QC Memo 0.00
 Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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MF
11-10-39

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 74877

74877

Parent Item: D3490-3

D3490-3

Parent Item Name: Cross Bolt Spacer

Start Date: 10/13/11

Required Date: 10/27/11

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A New Issue 06-03-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit 300	Total Qty	Qty Issued	Date Issued	Status
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M6061T6R0.750

Purchased

No

100

f

6.1780

0.266

11.2

M6061T6R0 750

6061-T6 Round Bar .750"

**

10.700

SL 10/10/23

Location

Loc Qty

Loc Code

MAT013

6.178

112442

0.796

116406

0.617

117481

2.51

118106

2.255

11.5

10.700

11.5

1.166 FT

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Dart Aerospace Ltd

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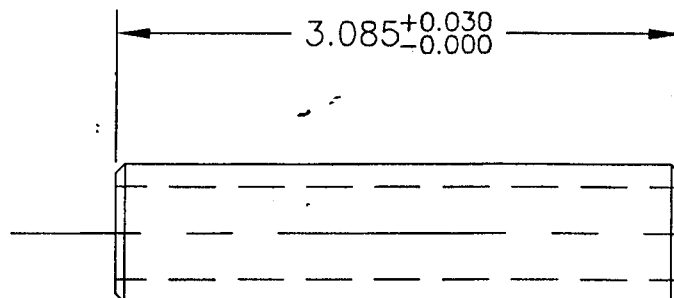
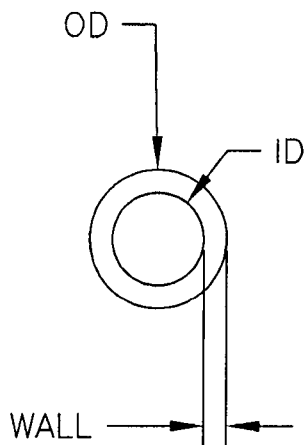
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NOTE: Date & initial all entries



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3490	REV. A SHEET 1 OF 1
DATE 06.01.04		TITLE CROSS BOLT SPACER	SCALE NTS
A	06.01.04	NEW ISSUE	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74837

M.L.J

11/10/14

0.050 X 45°
CHAMFER (TYP)

D3490-1/-3/-5 CROSS BOLT SPACER PARTS LIST

PART NUMBER	OD	WALL	ID (REF)	MATERIAL SPEC
D3490-1	0.500	0.049	0.402	M6061T6T0.500W.049
D3490-3	0.750	0.080	0.591	M6061T6R0.750
D3490-5	0.313	0.058	0.197	M6061T6T0.313W.058

D3490-1/-3/-5 CROSS BOLT SPACER

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
06-02-07

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